

# Work Order ID 119726

May-20-14 11:36:56 AM

**\*119726\***

Page 1

Item ID: D5080-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Angle Bracket  
 Start Date: 5/20/14 Start Qty: 60.00 **\*60\* 72** Cust Item ID:  
 Required Date: 5/23/14 Req'd Qty: 60.00 **\*60\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 4-05-20 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D5080	A								
100	FLOW WATER JET	0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
37  
9-89/mm  
14/05/22

DAS  
37  
9-89/mm  
14/05/22

Smf  
14/5/23

Can

# Work Order ID 119726

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**\*119726\***

Page 2

Item ID: D5080-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Angle Bracket  
 Start Date: 5/20/14 Start Qty: 60.00 **\*60\*** Cust Item ID:  
 Required Date: 5/23/14 Req'd Qty: 60.00 **\*60\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		DAS 30 9-89		72			14/05/26
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		DAS 27 9-89 14/5/26		72 con			
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>ST129</u> Memo	0.00 0.00				72x		<del>72</del> 14-5-29	

DAS  
26  
9-89

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\*119726\*

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Item ID: D5080-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Angle Bracket

Start Date: 5/20/14 Start Qty: 60.00

\*60\*

Cust Item ID:

Required Date: 5/23/14 Req'd Qty: 60.00

\*60\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21 - Final Inspection - Work Order Release

0.00

\*160\*

QC

Memo

0.00

Quality Control

14/5/30 DJ

14-5-2a

# Picklist Print

May-20-14 11:36:55 AM

Page 1

Work Order ID: 119726

\*119726\*

Parent Item: D5080-1

\*D5080-1\*

Parent Item Name: Angle Bracket

Start Date: 5/20/14

Required Date: 5/23/14

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 14.03.19 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

sf

572.1100

3

**\*M304S18GA\***

\*\*

mm 14/05/22

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT019

560.11

117188

3

117766

5

120604

5

122325

3

123155

3

124572

38

M126647

39.75

M128254

102.11

M128435

187.25

M128864

174

MAT020

12

124029

2

M126098

10

3.1

DART AEROSPACE LTD		Work Order:	119726
Description: Angle Bracket		Part Number:	D5030-1F
Inspection Dwg: D5030	Rev: A	Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

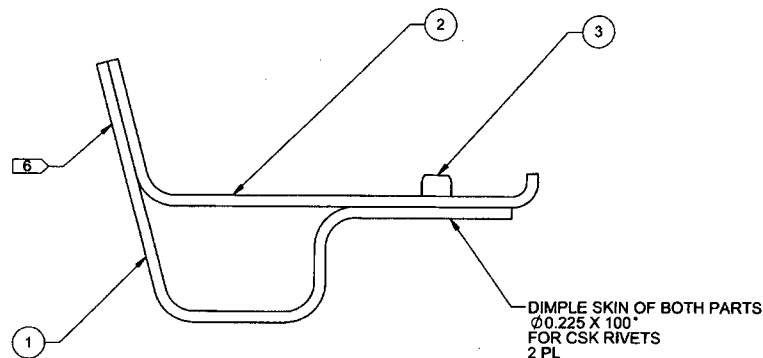
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DAS					
Measured by:	37	Audited by:	ShB	Preliminary Approval:	
Date:	9-89 <i>mm</i> 14/05/22	Date:	14/5/23	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

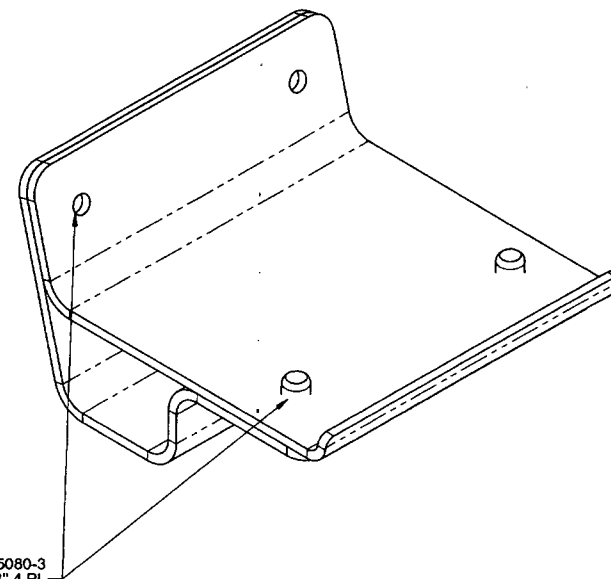
10.04.15

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5080-041	STRIKER PLATE ASSY
1	1	D5080-1	ANGLE BRACKET
2	1	D5080-3	STRIKER PLATE
3	2	MS20426AD4-4	RIVET, SOLID, CSK



**D5080-041 STRIKER PLATE ASSY**

TRANSFER MARK HOLES FROM D5080-3  
TO D5080-1 AND DRILL Ø0.128" 4 PL



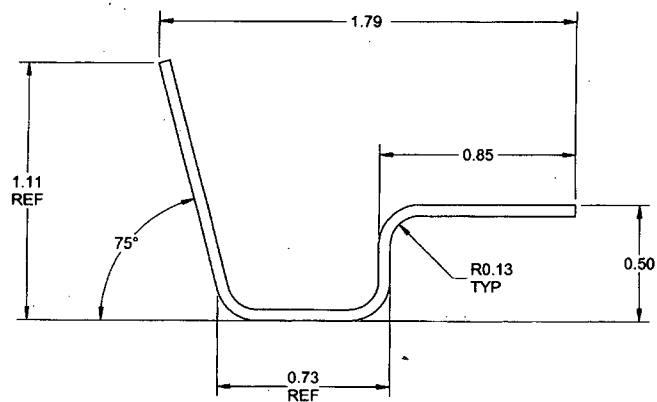
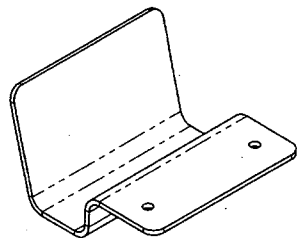
RELEASED  
2014-04-23

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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

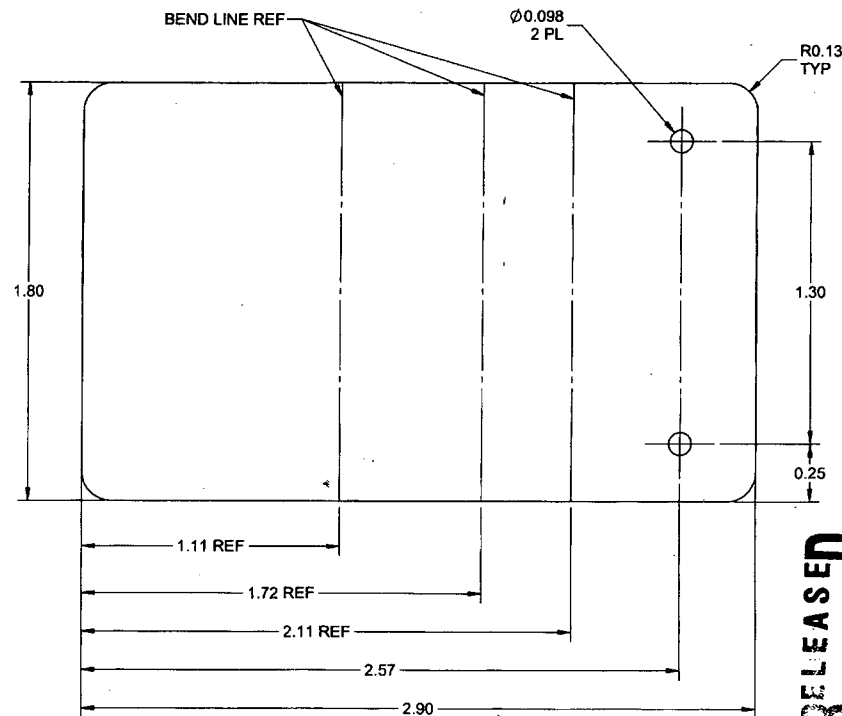
NO. 19726 MLC  
14-05-20

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.1
  - 7) WEIGHT: 0.13 lbs

APPROVED	REV.	NEW ISSUE	ML	14.03.24
	DESIGN	ML	BY	DATE
	DRAWN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AJS	DRAWING NO.	REV. A
	MFG. APPR.	DD	D5080	SHEET 1 OF 3
	APPROVED	MP	TITLE	SCALE
	DE APPR.	DS	STRIKER PLATE ASSY	NTS
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**D5080-1 ANGLE BRACKET**  
MAKE FROM D5080-1F



**D5080-1F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

APPROVED

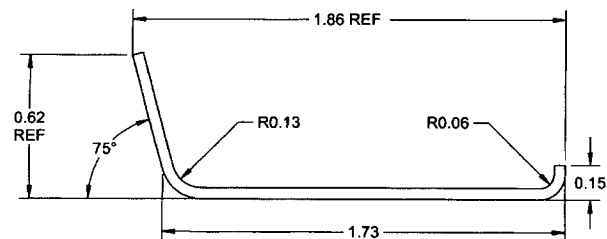
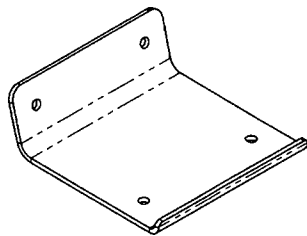
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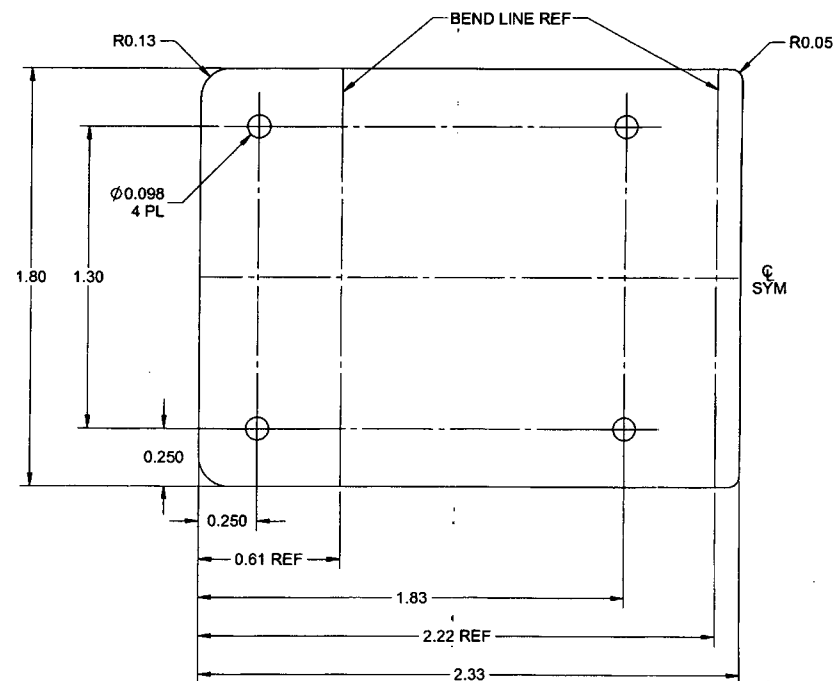
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D5080	SHEET 2 OF 3
TITLE	SCALE
STRIKER PLATE ASSY	NTS

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2014-04-23



**D5080-3 STRIKER PLATE**  
MAKE FROM D5080-3F



**D5080-3F FLAT PATTERN**

**RELEASED**  
2014-04-23

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.048" THICK)  
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240  
REF. DART SPEC M304S18GA
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.06 lbs

APPROVED

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CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.	DD	<b>D5080</b>	SHEET 3 OF 3
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